

Work Order ID 52370

Tuesday, September 22, 2009 3:13:26 PM



Page 1

Item ID: D3135-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Handle Weldment

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*mf*Date: *09-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3135

Rev D

2

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3135-3 ☒ Dwg Rev: *D* ☐ Prog Rev: *D* ☐ 2-
Debur if necessary*IB 9-4-30**(5)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 9-4-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*27 507/01/30**(+5)*

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Bend D3135-1 as per template D3135-1T2 and Dwg D3135-2-Deburr ends

M.P. 09/09/30

5X

140



QC

QC5- Inspect part completeness to step on W/O

0.00

=> 802/02/30

0.00

Memo

X5

φ

Quality Control

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Weld handle onto plate as per Dwg D3135 and QSI 004 304 S.S. welding
rod Batch: M 109213

SLY 09/10/01

5X

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Pl 09 10 01

170 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

2) 802/10/01

(X5) /

180 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:00pm FINISH TIME: 2:30pm OVEN TEMPERATURE: 320°F

M109091

=> 11 802/10/01

(X5) /

Picklist Print

Page 1

Tuesday, September 22, 2009 3:13:25 PM

Work Order ID: 52370



Parent Item: D3135-041RevD



Parent Item Name: Handle Weldment

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.375W.065		Purchased	No			100	f	67.7900	1.7545			
304 RD Tube .375 x .065W												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

67.79

111097 ✓

60

18457

3.89

18993

3.9

M304S16GA

Purchased

No

130

sf

205.2400

1.2632

304/316 Sheet .063



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

205.2399737

106860

16.018

111924

25.1689737

112442

68.053

112567

96

Mk 09/09/30

M111097

→ 1.5790

B99-36

112442

SHOP COPY

RETURN TO

ENGINEERING

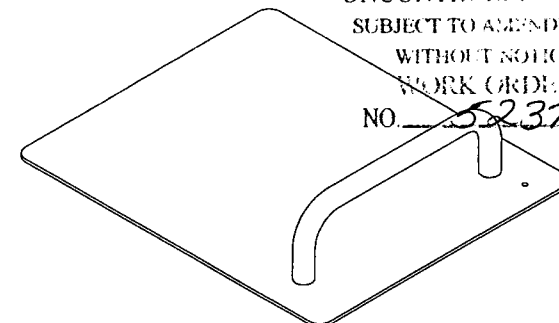
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

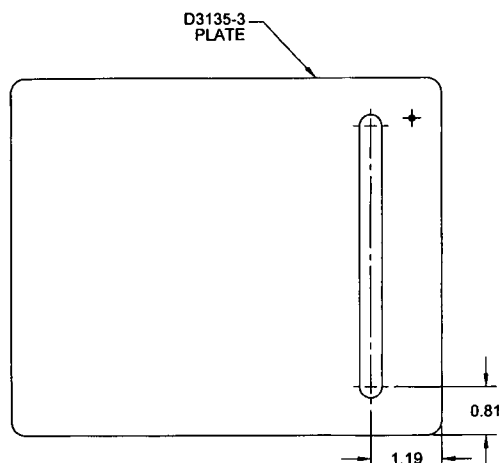
WORK ORDER

NO. 52370

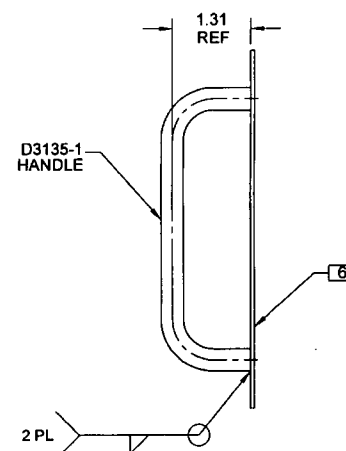


D3135-041 HANDLE WELDMENT

QTY. -041	PART NUMBER	DESCRIPTION
X	D3135-041	HANDLE WELDMENT
1	D3135-1	HANDLE
1	D3135-3	PLATE



D3135-041 HANDLE WELDMENT



RELEASED

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT COLOUR GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3135-041" AND BATCH "BXXXXX" USING FINE POINT PERMANENT INK MARKER OR FIX LABEL AFTER FINISHING
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004

D	REDRAWN TO SOLIDWORKS FORMAT. ZN D4-2 TOOLING HOLE ADDED. REASON: PRODUCTION REQUEST FOR TOOLING HOLE.	AJS	08.05.07
C	REMOVED Ø0.221 HOLES	DS	04.10.06
B	6.400 WAS 6.330; ADD "ANNEALED"	DS	03.03.04
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3135	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HANDLE WELDMENT	NTS
DATE	08.05.07	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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